



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2435

Job Sheet 173352

Part No: D2435

Job Qty: 20 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/28/18

Job Tracking No:

Due Date: 3/19/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG REV E1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		3/16/18	0.00	0.00	Start Up Container		DE 18/03/06
120	Waterjet	20 pcs		3/16/18	0.00	3.72	Waterjet1		DE 18/03/06
130	CNC Vertical Machining	20 pcs		3/19/18	0.41	20.28	HAAS 1		DE 18/03/06
150	QC	20 pcs		3/19/18	0.00	0.00	QC8		DE 18/03/06
151	Packaging	20 pcs		3/19/18	0.00	0.00	Packaging3		DE 18/03/06
190	QC21-SA	20 Ea		3/19/18	0.00	0.00	QC21		DE 18/03/06

Part Op 120 - CUT BLANK AS PER FILE D2435

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	64 sf (3.2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	64	2,168	0



Container No: S048556

Part: D2435

Job No: 173352

Serial No/Batch: S048556

Revision:

Inspector:

Date: 03/06/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Newcastle, ON K6A 1K7
CANADA
TEL: 1 813 832-8200
Email: sales@dartaero.com
www.dartaerospace.com

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053	.063	
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	45° Angle	
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470	5.500	
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170	.195	
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	0.250 Radius	
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.255 RAD	
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595	0.630	
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240	0.250	
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	45° Angle	
10	Bearpaw	0.375Inches ± 0.010	0.385 0.365	0.382	
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970	19.00	
12	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	.955	
13	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	0.260 Diameter	
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	0.931 Diameter	
15	Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300	0.310	
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345	0.377	
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345	7.375	
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240	4.250	
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970	2.000	
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990	9.000	
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720	15.750	

Plex 2/28/18 2:45 PM dart.logan.david

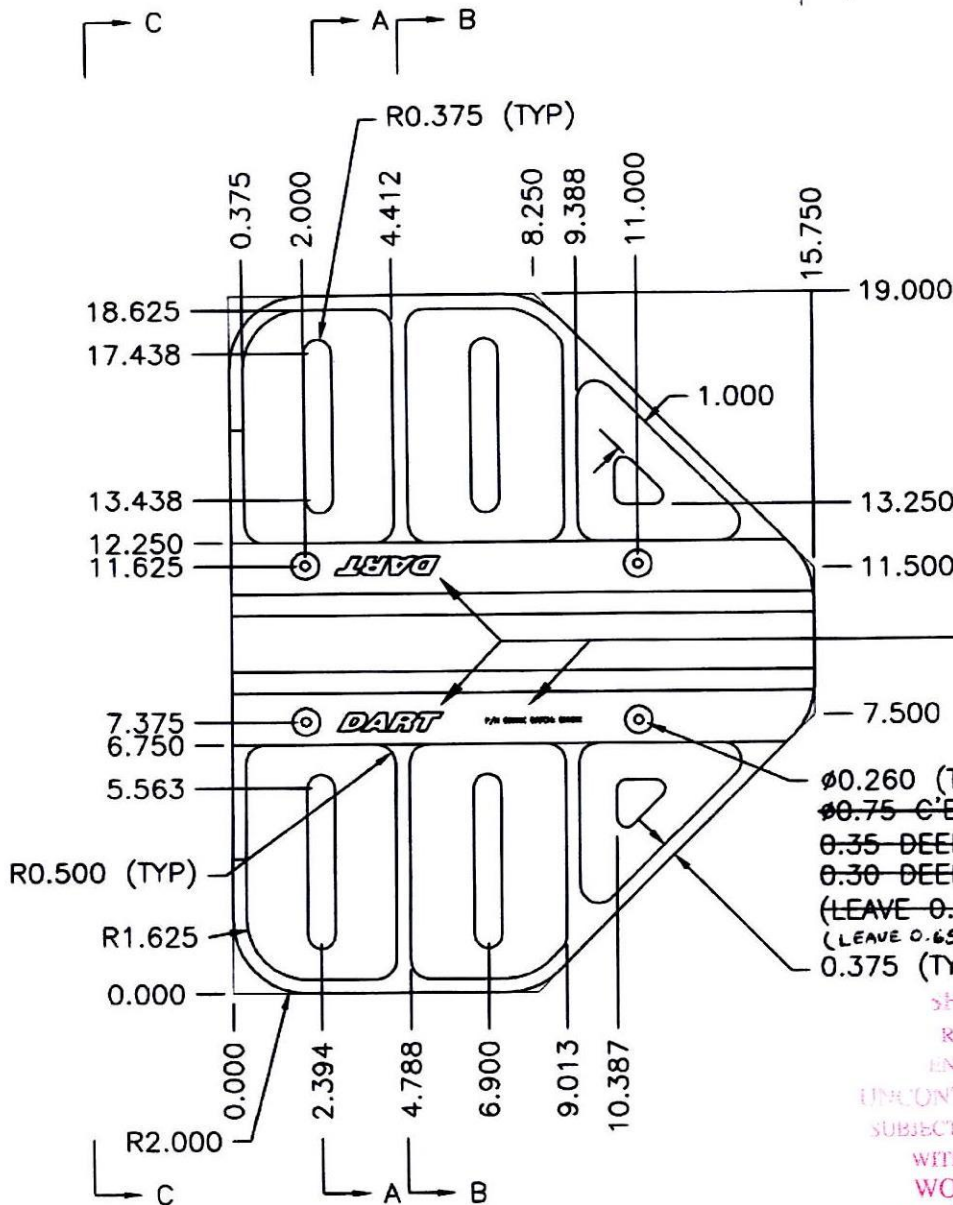
QA COPY ISSUED

98-06-17 KE

98.06.17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	
KE	KE	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
MB	JS	D2435	SHEET 1 OF 2
DATE		TITLE	SCALE
98.05.19		BEARPAW	1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	
		EFFECTIVE	DEOS

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



~~Ø0.260 (TYP) Ø0.93 C'BORE~~
~~Ø0.75 C'BORE 0.30 DEEP FROM BOTTOM~~
~~0.35 DEEP FROM TOP (MIN.)~~
~~0.30 DEEP FROM BOTTOM~~
~~(LEAVE 0.300 MIN.)~~ 
~~(LEAVE 0.650 MIN.)~~
~~0.375 (TYP)~~ 

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173352

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689 2018030
1.00 THICK (MACHINE TO 0.950)

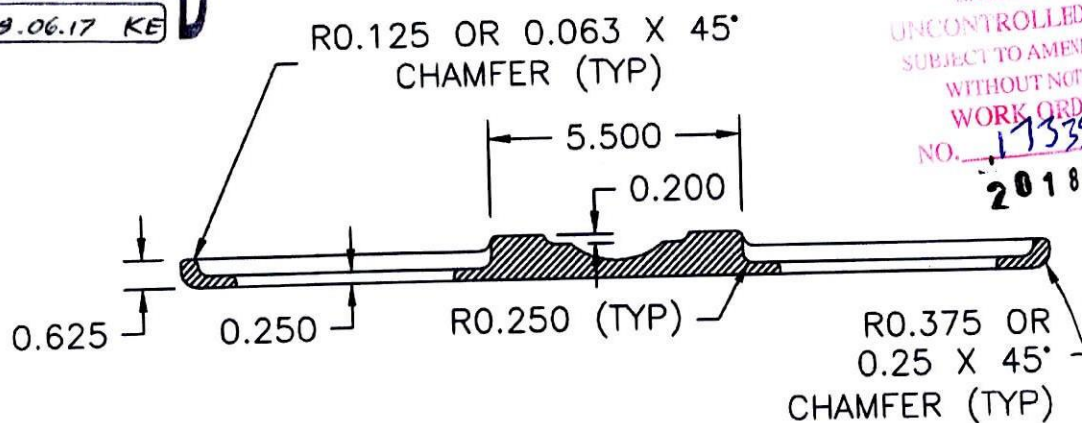
DART



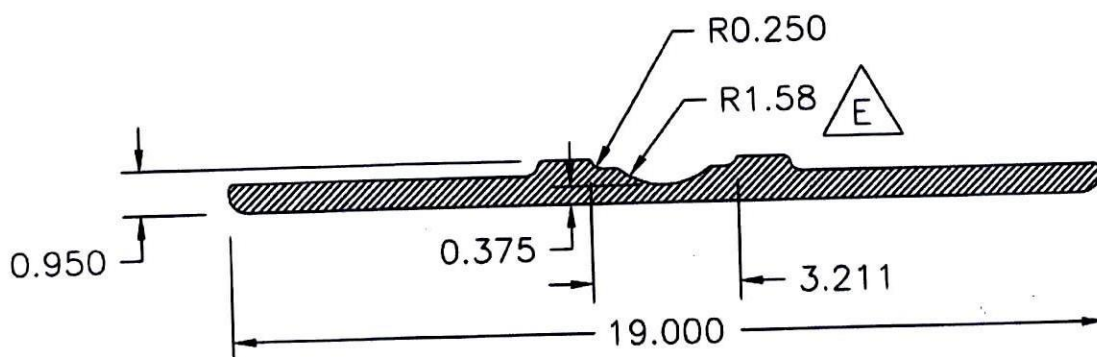
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DM</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE

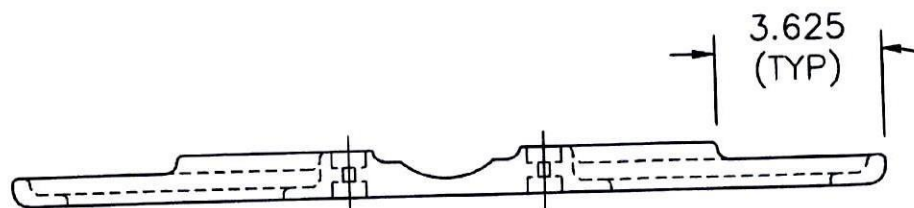
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 17352
20180 301



SECTION A-A



SECTION B-B



SECTION C-C